

Date: Tuesday, 5/23/2006 2:31:00 PM  
 User: Linda Lacelle

## Process Sheet

*Split*  
*SB 06/05/25*

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STUB COVER
Job Number	: 27233		
Estimate Number	: 12415		
P.O. Number	: <i>N/A</i>	Part Number	: D34941
This Issue	: 5/23/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3494 REV A
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: <i>N/A</i>	Material	: <i>N/A</i>
Written By	: <i>SEE COMMENT BELOW</i>	Due Date	: 5/30/2006
Checked & Approved By	: <i>SEE ABOVE USER &amp; DATE</i>	Qty:	<i>10</i> Um: Each
Comments:	<i>Est Rev A New Issue 06-05-19-11M</i>		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.6972 sf(s)/Unit Total: 2.7888 sf(s)

304/316 .063 Sheet

(M304S16GA)

Batch: *M7106 (2) M19059 (6)**5.10 06-05-24 10*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3494

Dwg Rev: *A*Prog Rev: *A**SAD 06-05-24*

2-Debur if necessary

*M.F. 06-05-26 - (6)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 06-04-24 (4)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SB 06/05/25*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Form as per Dwg D3494

*SB 06/05/30**(6)*





Date: Tuesday, 5/23/2006 2:31:00 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUB COVER

Job Number: 27233

Part Number: D34941

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



*06.05.30*

(6)

Comment: INSPECT WORK TO CURRENT STEP

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3494

A/R SS ROD Batch: *M100322*

*06/05/30 (6)*

8.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*PD 06-05-31 (6)*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*FC 06 05 31 (6)*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*a.m 06-05-31 (6)*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *356*

*CY 06/05/31 (6)*

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/05/31 (6)*

Job Completion



*CY 06/05/31*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/05/24		<del>Part</del> Dimension don't match with the drawing (new Prod)	<i>[Signature]</i> 06/05/24	serp + replace	CT 06/05/24	<i>[Signature]</i> 06/05/24	<i>[Signature]</i> 06/05/24	<i>[Signature]</i> 06/05/24

Part No: 1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 06/05/24

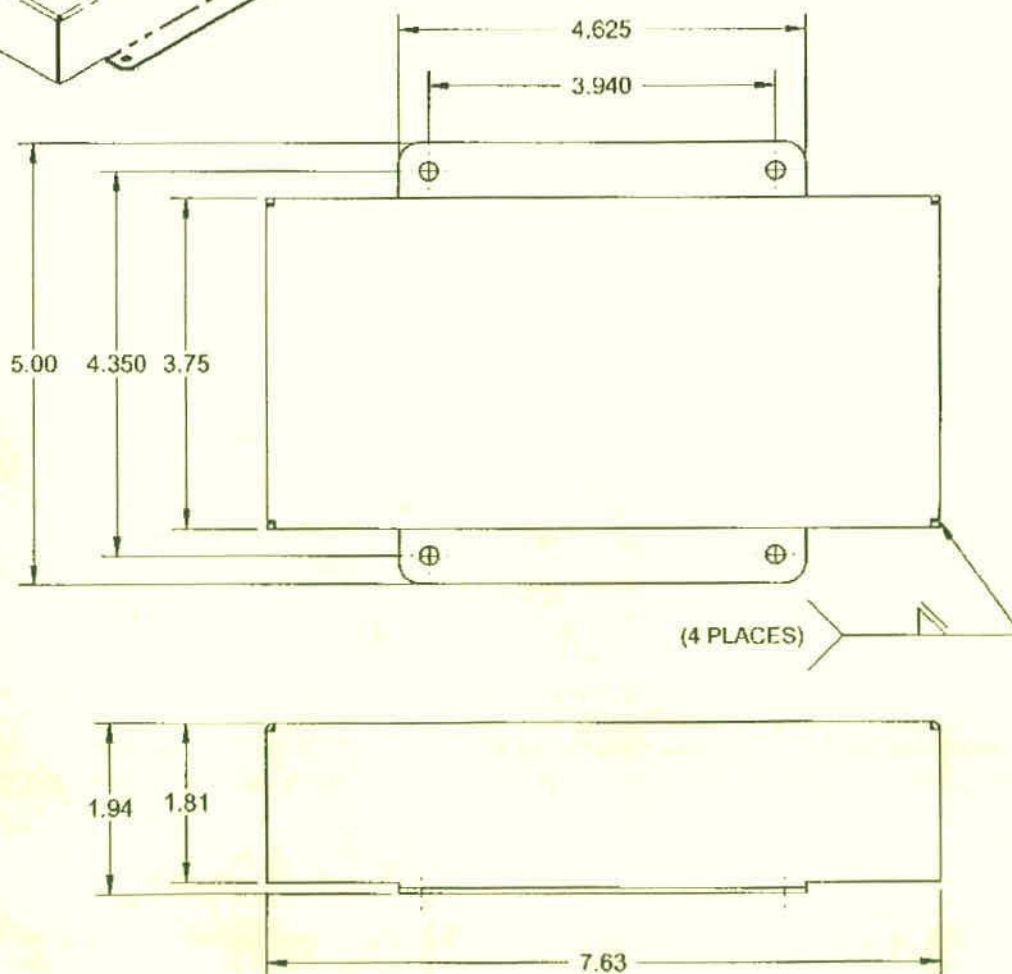
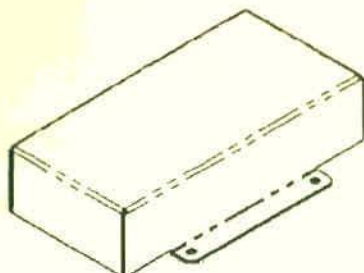
NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





**DART**

DESIGN MB	DRAWN BY MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3494	REV. A SHEET 1 OF 2
DATE 06.01.16		TITLE STUB COVER	SCALE 1:2
A	06.01.16	NEW ISSUE	

**REFERENCE ONLY****NOTES:**

- 1) MATERIAL: MAKE FROM D3494-1F
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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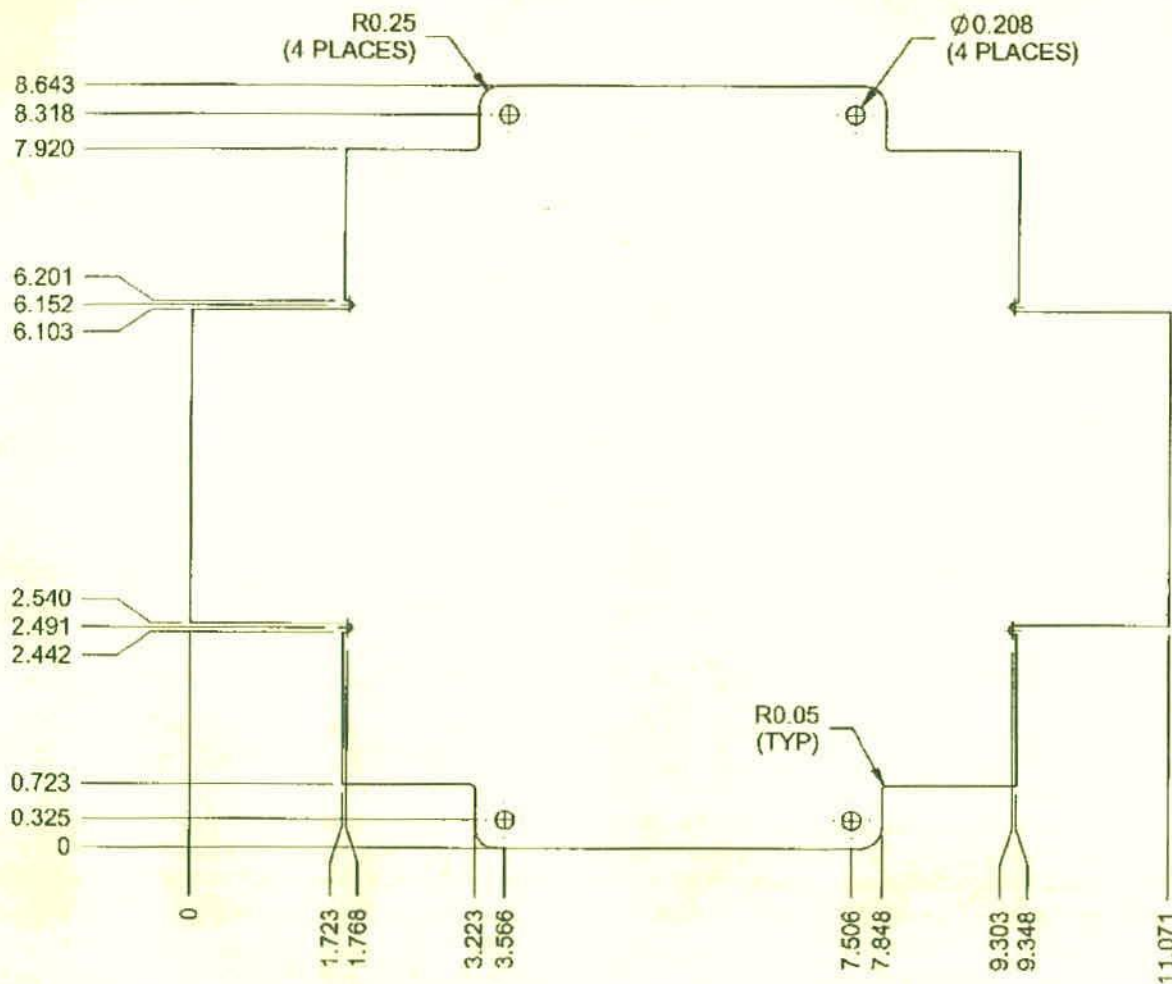




**DART**

REFERENCE ONLY

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3494	REV. A
DATE 06.01.16		TITLE STUB COVER	SHEET 2 OF 2 SCALE 1:2

**D3494-1F STUB COVER FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.060 THICK) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order: 27233
Description:		Part Number: D34941
Inspection Dwg:	Rev:	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.643	$\pm 0.010$	8.645	✓		Vern	
8.318	$\pm 0.010$	8.310	✓		Vern	
7.920	$\pm 0.010$	7.918	✓		Vern	
6.201	$\pm 0.010$	6.202	✓		Vern	
6.152	$\pm 0.010$	6.155	✓		Vern	
6.103	$\pm 0.010$	6.105	✓		Vern	
2.540	$\pm 0.010$	2.544	✓		Vern	
2.491	$\pm 0.010$	2.496	✓		Vern	
2.442	$\pm 0.010$	2.446	✓		Vern	
0.723	$\pm 0.010$	0.720	✓		Vern	
0.325	$\pm 0.010$	0.327	✓		Vern	
1.723	$\pm 0.010$	1.724	✓		Vern	
1.768	$\pm 0.010$	1.770	✓		Vern	
3.223	$\pm 0.010$	3.232	✓		Vern	
3.566	$\pm 0.010$	3.568	✓		Vern	
7.506	$\pm 0.010$	7.509	✓		Vern	
7.848	$\pm 0.010$	7.852	✓		Vern	
9.303	$\pm 0.010$	9.308	✓		Vern	
9.348	$\pm 0.010$	9.358	✓		Vern	
11.071	$\pm 0.010$	11.081	✓		Vern	
Ø 0.208	$+0.005/-0.001$	Ø 0.210	✓		Vern	
RO.25	$\pm 0.010$	RO.25	✓		Radius gauge	
RO.05	$\pm 0.010$	RO.05	✓		Radius gauge	

Measured by: SAD/BC	Audited by: Ep	Prototype Approval:
Date: 06/04/24	Date: 06/05/25	Date:

Rev	Date	Change	Revised by	Approved
1		New Issue	KJ/JLM	